

Date: Wednesday, 12/11/2008 8:47:24 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SQUARE SLEEVE
Job Number :	43329		
Estimate Number :	13470		
P.O. Number :		Part Number :	PB6743001121
This Issue :	12/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 PAGE34
First Issue :	/ /	Project Number :	N/A
Previous Run :	41866	Drawing Revision :	B1
	Type :	Material :	
	MACHINED PARTS	Due Date :	19/11/2008
Written By :		Qty:	10
Checked & Approved By :	<u>mf 08-11-12</u>	Um:	Each
Comment :	Est Rev:A 08-07-17 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25
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Comment: Qty.: 0.4112 f(s)/Unit Total: 4.1118 f(s)

6061T6 bar 1.25 x 1.25

batch: Mb9058

J.F.

08/11/12

(10)

2.0	BAND SAW	BAND SAW
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Comment: Cut blank 4.8" long

J.F.

08/11/12

(10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: 1- Machine as per Folio FA567 and Dwg PB67-43001
 2- deburr

mf 08/11/13

(16)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/11/13

(16)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M.A 08/11/13

(10)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

Fdx 08/11/14

(10)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE SLEEVE

Job Number: 43329

Part Number: PB6743001121

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M102316



10X

Comment: POWDER COATING

1- mask inside of tube before powder coating

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30
320 OF
12:00

M-1 08/11/14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08-11-14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST.

MF 08-11-14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/17

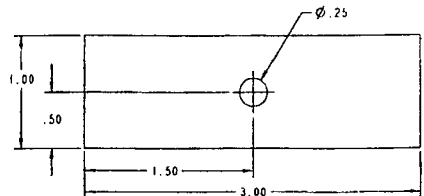
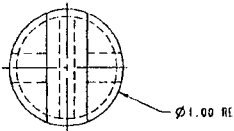
Job Completion



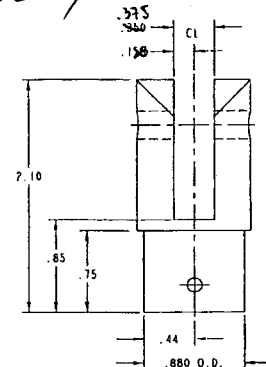
MF 08-11-14

RELEASED

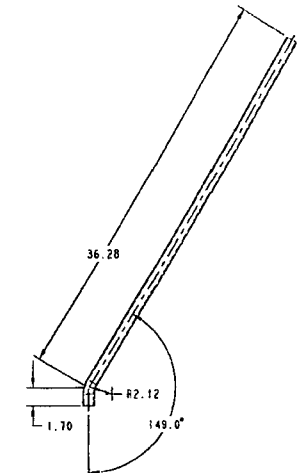
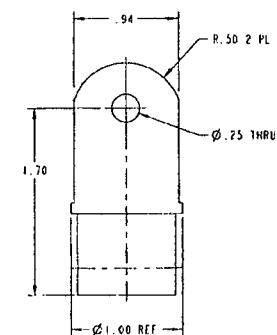
43329



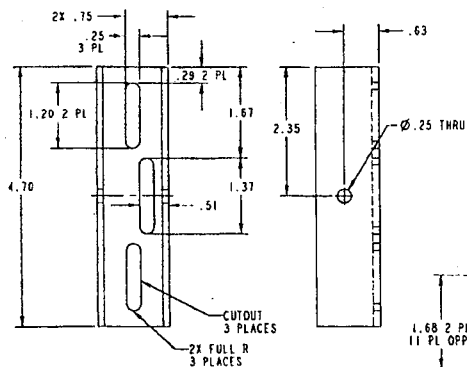
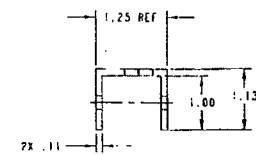
① -271 DOUBLER
MATERIAL: .125 THK, 6061-T6, QQ-A-250/11
SCALE 2.000



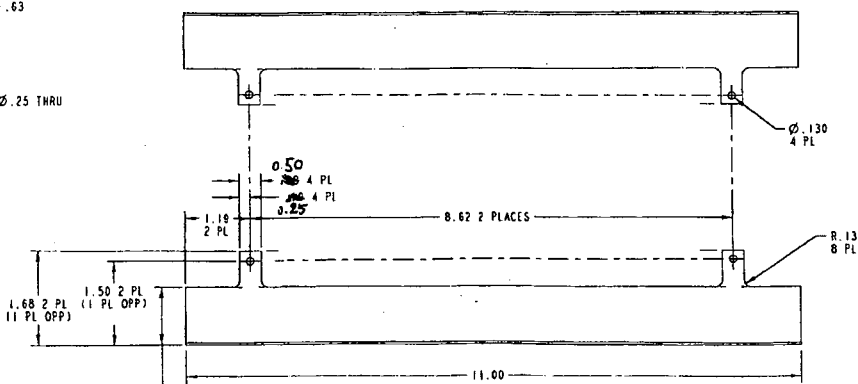
① -125 CLEVIS
MATERIAL: 1.00 RND, 6061-T6, QQ-A-200/8
SCALE 2.000



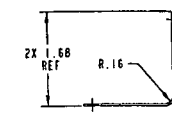
① -343 TUBE ARM
MATERIAL: 1.00 O/D X .065 WALL 6061-T6 TUBE
W-1-700/6
SCALE 0.200



① -121 SQUARE SLEEVE
MATERIAL: 1.25 SD, 7075-T6, QQ-A-200/11
SCALE 1.000



① -267 PAD ATTACHMENT FIXTURE
MATERIAL: .032 THK 7024-T3, QQ-A-250/4
SCALE 1.000



PREMIER AVIATION, INC.
5000 Aviation Parkway, Grand Prairie, Texas 75052
D105UV8 B67-43001
SCALE: 1/4" = 1" SHEET: 34 of 45

ORIGINAL

